

tesa® HAF 8405



product information

30µm amber reactive HAF mounting tape

tesa® HAF 8405 is a reactive heat activated film based on phenolic resin and nitrile rubber. This amber double sided tape has no backing. It is protected by a strong paper liner and can easily be slit and die cut.

At room temperature tesa® HAF 8405 is not tacky. It is activated by heat and starts to become tacky at 90 °C for pre-lamination. In a second application step heat and pressure is applied over a certain period of time.

After curing tesa® HAF 8405 reaches:

- *Very high bonding strength
- *High temperature resistance
- *Excellent chemical resistance
- *Bonds remain flexible and elastic

Main Application

It is suitable for bonding of all thermal resistant materials such as metal, glass, plastic, wood and textiles.

- *Friction liner for clutches

Technical Information (average values)

The values in this section should be considered representative or typical only and should not be used for specification purposes.

Technical Data

• Backing material	none	• Bonding strength	12 N/mm ²
• Color	amber	• Shelf life time < 5°C	18 months
• Total thickness	30 µm	• Shelf life time < 15°C	15 months
• Type of adhesive	nitrile rubber / phenolic resin	• Shelf life time < 25°C	12 months
• Type of liner	glassine		

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Additional Information

Processing:

1. Pre-lamination:

tesa® HAF 8405 is laminated before curing. For this process we recommend a temperature between 120 °C and 140 °C.

2. Bonding:

The bonding conditions temperature, pressure and time depend on the application. Following parameters can be regarded as a guideline:

Friction liners for clutches:

*Temperature: 180 – 230 °C

*Pressure: > 8 bar

*Time: 3 min – 30 min

Bonding strength values were obtained under standard laboratory conditions. Value is guaranteed clearance limit checked with each production batch (Material: Etched aluminium test specimen / Bonding conditions: Temp. = 120 °C; p = 10 bar; t = 8 min)

To reach maximum bonding strength surfaces should be clean and dry. Storage conditions according to tesa® HAF shelf life concept.

Disclaimer

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